



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82228

\*82228\*

Page 2

March-27-12 7:59:54 AM

Item ID: D2893-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: 2.75 Support

Start Date: 27/03/2012 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00

\*130\*

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Per note 8 on page 1 of dwg D2893. Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time.

At 12 - 4 - 12 (12)

140

QC3- Inspect Part Finish

0.00

\*140\*

QC

Memo

0.00

Quality Control

(12)

12 04 14

170

Identify as per dwg & Stock Location: Y-tube

0.00

\*170\*

Packaging

Memo

0.00

Packaging

ASS'Y

(12)

12 04 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 82228

March-27-12 7:59:54 AM

\*82228\*

Page 3

Item ID: D2893-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: 2.75 Support

Start Date: 27/03/2012 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

QC21- Final Inspection - Work Order Release

0.00

\*180\*

QC

Memo

0.00

Quality Control

12/4/17 JG  
p12-04-16

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-27-12 7:59:57 AM

Page 1

Work Order ID: 82228

\*82228\*

Parent Item: D2893-1

\*D2893-1\*

Parent Item Name: 2.75 Support

Start Date: 27/03/2012

Required Date: 04/05/2012

Start Qty: 20.00

Required Qty: 20.00

## Comments:

IPP: C02.11.26Reformat: Added P/OKJ

IPP: D 06.04.19 removed alodine EC

IPP Rev:E Added priming as per Rev B 07-04-30 JLM

IPP: F 08.03.19 Re-format EC verified by: DD

IPP Rev:G 08-05-15 add QC14 DD verified by:EC

IPP Rev:H

11.08.04 as per dwg rev.C DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

DSK078

Manufactured No

100

Each

20.0000

0.5

10.52632

\*DSK078\*

\*\*

10

LF 12/04/08

D2893-1 TURNING DETAIL

Location

Loc Qty

Loc Code

MAT

-10

MAT060

30

80157

20

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

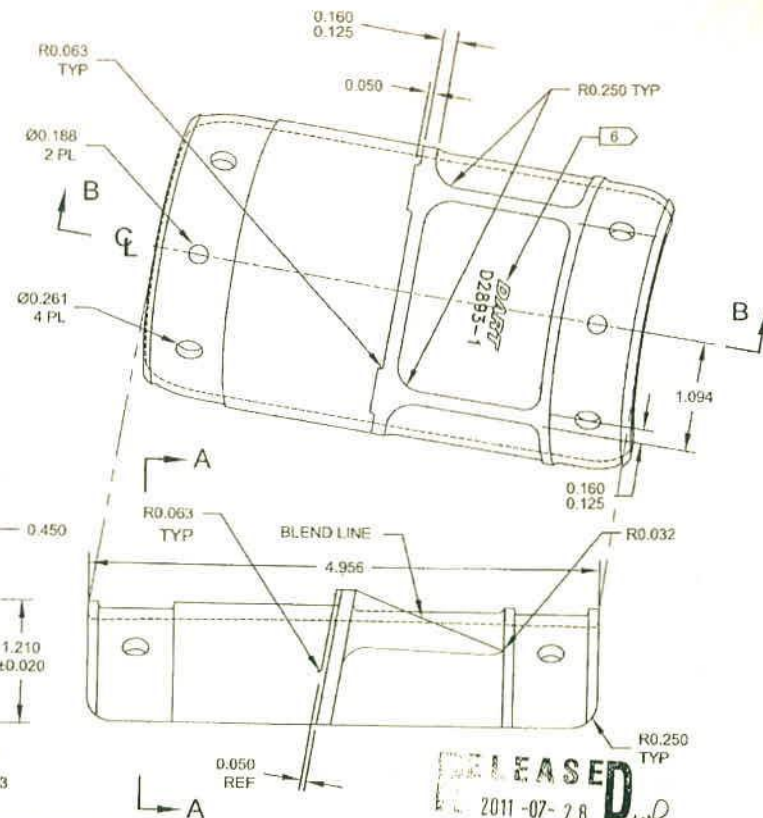
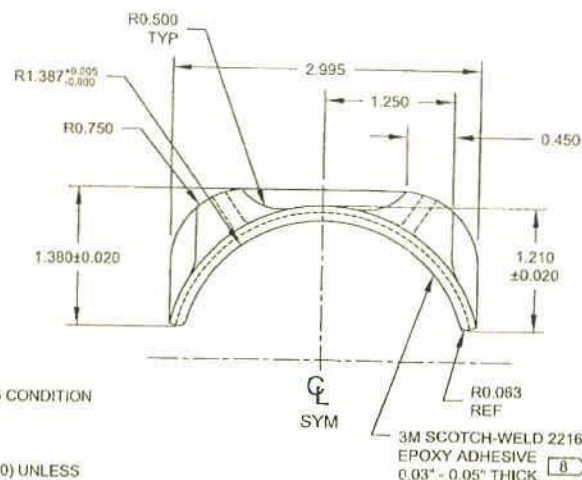
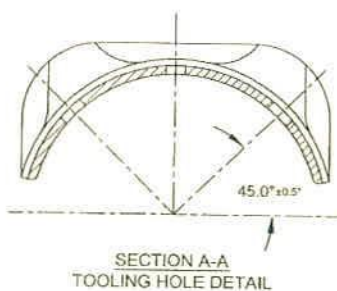
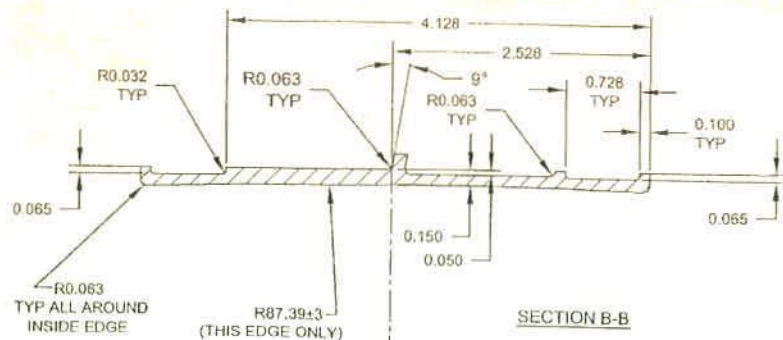
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





#### NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION  
MIN UTS = 170 KSI (38 HRC)  
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.78 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:  
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03\"/>

#### D2893-1 SUPPORT

REV.	DESCRIPTION	BY	DATE
C	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE DIMS AS MFG, PRIME INSIDE	PH	07.03.16
A	NEW ISSUE	CP	01.01.10
DESIGN	DRAWN	CHECKED	MFG. APPR.
	AS		
APPROVED	DE APPR.	TITLE	SCALE
		D2.750 SUPPORT	NTS
DATE	11.07.15	COPYRIGHT © 2001 BY DART AEROSPACE LTD	

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WORK ORDER

82228 MJS

12/03/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order:	82228
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.992	2.990	2.993	2.993	2.993
AB	0.440	0.460		0.4405	.445	.445	.455	.445
AC	0.125	0.160		0.130	.130	.135	.135	.135
AD	0.040	0.060		0.052	.048	.052	.048	.052
AE	0.188	0.193		0.190	.190	.190	.190	.190
AF	0.125	0.160		0.145	.145	.145	.145	.145
AG	0.140	0.160		0.146	.153	.153	.152	.155
AH	1.360	1.400		1.3745	1.3745	1.375	1.378	1.373
AI	0.040	0.060		0.049	.050	.046	.052	.050
AJ	1.190	1.230		1.218	1.220	1.215	1.2185	1.218
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		0.063	.063	.063	.063	.063
AM	0.240	0.260		0.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.530	2.528	2.530	2.531
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.261	.261	.261	.261	.261
AQ	0.053	0.073		0.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	AA 12/04/08	Date:	12/04/08
Audited by:	TR	Date:	12.4.12
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order: 82228
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6	7	8	9	10
HAAS Section								
AA	2.985	3.005		2.994	2.994	2.994		
AB	0.440	0.460		.440	.455	.455		
AC	0.125	0.160		.139	.138	.138		
AD	0.040	0.060		.048	.048	.048		
AE	0.188	0.193		.190	.190	.190		
AF	0.125	0.160		.143	.140	.142		
AG	0.140	0.160		.155	.152	.155		
AH	1.360	1.400		1.371	1.370	1.371		
AI	0.040	0.060		.048	.052	.050		
AJ	1.190	1.230		1.213	1.214	1.214		
AK	0.010	0.020		.015	.015	.015		
AL	0.053	0.073		.063	.063	.063		
AM	0.240	0.260		.250	.250	.250		
AN	2.518	2.538		2.530	2.530	2.532		
AO	84.39	90.39		87.37	87.39	87.39		
AP	0.261	0.266		.261	.261	.261		
AQ	0.053	0.073		.063	.063	.063		
AR								
AS								
AT								
Accept/Reject								

Measured by: <i>HS</i>	Date: 12/04/09
Audited by: <i>TRC</i>	Date: 12.4.12
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order: 82258
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.9955	2.9955	2.9935	2.993	2.995
AB	0.440	0.460		.460	.457	.450	.455	.455
AC	0.125	0.160		.137	.135	.138	.138	.138
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.143	.143	.143	.140	.145
AG	0.140	0.160		.151	.152	.1525	.154	.154
AH	1.360	1.400		1.373	1.371	1.368	1.370	1.377
AI	0.040	0.060		.0505	.049	.0505	.0495	.048
AJ	1.190	1.230		1.2165	1.2145	1.214	1.214	1.2215
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.530	2.529	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: JH/FK 12/04/10	Date: 12/04/09
Audited by: DG	Date: 12-4-12
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 82228
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	2.985	3.005		2.995	2.995	2.995	2.994	2.994
AB	0.440	0.460		.455	.455	.455	.455	.455
AC	0.125	0.160		.138	.138	.138	.138	.138
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.145	.145	.145	.145	.145
AG	0.140	0.160		.153	.153	.154	.153	.154
AH	1.360	1.400		1.369	1.370	1.375	1.370	1.373
AI	0.040	0.060		.048	.051	.049	.050	.051
AJ	1.190	1.230		1.216	1.214	1.218	1.216	1.216
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.529	2.529	2.530	2.529	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: FK/AM

Date: 12/04/10

Audited by: TR

Date: 12.4.12

Prototype Approval:

Date:

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Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions			
Dim	Min	Max	Go/No Go Gauge	11	12		
HAAS Section							
AA	2.985	3.005		2.995	2.995		
AB	0.440	0.460		.455	.455		
AC	0.125	0.160		.138	.138		
AD	0.040	0.060		.051	.050		
AE	0.188	0.193		.189	.189		
AF	0.125	0.160		.146	.146		
AG	0.140	0.160		.153	.151		
AH	1.360	1.400		1.374	1.375		
AI	0.040	0.060		.047	.050		
AJ	1.190	1.230		1.219	1.222		
AK	0.010	0.020		.015	.015		
AL	0.053	0.073		.063	.063		
AM	0.240	0.260		.250	.250		
AN	2.518	2.538		2.530	2.530		
AO	84.39	90.39		87.39	87.39		
AP	0.261	0.266		.261	.261		
AQ	0.053	0.073		.063	.063		
AR							
AS							
AT							
Accept/Reject							

Measured by: FK / ML	Date: 12/04/10
Audited by: DG	Date: 12.4.10
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